



# HiQ Quatro Clear (TC-4000)

Version 1.0

## PRODUCT DESCRIPTION

### ■ Outline

HiQ Quatro Clear is a general clearcoat designed for application in spray booths.

It is especially suitable for bodyshops requiring better thorough dry for superior productivity. Quatro Clear also has quick drying time and excellent appearance.

HiQ Quatro Clear is easy to apply and a high gloss acrylic urethane system with excellent durability.

### ■ Suitable Substrates

HiQ / Bodyian / Water-Q Basecoat

Sanded OEM Finishes

Fully-hardened two-component coatings (urethane, epoxy, etc.)

### ■ Product Configuration

Product Name	Pack(ℓ)	Contents(ℓ)	Storage
HiQ Quatro Clear (TC-4000)	4.0	4.0	24 months
HiQ Urethane Hardener (CCH-500, 530, 550)	1.0	1.0	12 months

\* Standard temperature of storage is 20°C.

### ■ Mixing Viscosity

13~16 sec. Viscosity(A+B) Ford Cup #4 at 77°F (25°C)

### ■ Pot Life

4 hours at 77°F (25°C) after mixing

### ■ Hardener

	Temperature			
	5~15°C	10~25°C	20~35°C	30°C or above
Spot repair	CCH-550	CCH-500	CCH-500	CCH-530
1~2 panel repair	CCH-550	CCH-500	CCH-500	CCH-530
Multi panel repair	CCH-550	CCH-500	CCH-530	CCH-530
Overall repair	CCH-500	CCH-500	CCH-530	CCH-530

## ■ Reducer

Reducer	Temperature				
	5~15°C	10~25°C	20~35°C	30°C or above	40°C or above
	DR-421W	DR-421WS	DR-421S	DR-421R	DR-421ER

## APPLICATION GUIDE

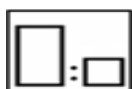
### ■ Use

Surface  
Preparation



Apply clearcoat after applying basecoat and wiping off the dust in the fully-dried condition.

Mixing  
Ratio



Product Name	Mixing Ratio
HiQ Quatro Clear (TC-4000)	4
HiQ Urethane Hardener (CCH-500, 530, 550)	1

\* Mix by volume.

Spray  
Condition



2.0~2.5 bar (gravity feed)  
2~3 wet coats keeping 20~25cm from the surface  
Fluid tip : 1.2~1.4mm, D.F.T.=40~60μm



3.0~4.0 bar (siphon feed)  
2~3 wet coats keeping 20~25cm from the surface  
Fluid tip : 1.4~1.6mm, D.F.T.=40~60μm



0.6~0.7 bar (at nozzle)  
2 wet coats keeping 20~25cm from the surface  
Fluid tip : 1.3~1.5mm, D.F.T.=40~60μm



Flash time : 5~8 min  
Set time : 8 min

Protective  
Equipment



Use fresh air mask or charcoal respirator to avoid inhaling or being exposed to fumes.

### ■ Drying Times

	Temp. Time		Temp. Time		Remark
	25°C	100~120 min	60°C	30 min	
Time to dust free	25°C	100~120 min	60°C	30 min	
Time to polish	25°C	7~9 hrs	60°C	30 min	
Time to handle	25°C	10~12 hrs	60°C	30 min	

(\*) If coats are thicker, the drying schedule will be delayed.

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## ADDITIONAL INFORMATION

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### ■ Recoatability

- 1) Recoatable time : 12 hours at ambient temperature after force dry
- 2) Sand and wipe off the dust with DR-180 before recoating.

*\* Do sand before recoating.*

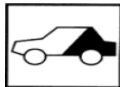


Dry sand P800



Wet sand P400 - P500

### ■ Blending



Product : HiQ Blending Reducer (DR-600)

Spray pressure : 2 bar

Number of coats : 1~2 coats

- Procedure :
- 1) Apply Quatro Clear.
  - 2) On the second application, apply wider than the first application area.
  - 3) Dilute Quatro Clear with DR-600 by the portion of 1:1 and apply once wider than the previous application area.
  - 4) Melt the edge of the previous coat using DR-600.

### ■ VOC Content

VOC content of 4.5lbs/gal (534g/liter)

### ■ Notice

1. For 2K products, short pot life, delayed drying time or unreactive substance can occur depending on hardener volume. Thus please mix base(A) and hardener(B) according to the proper mixing ratio.
2. Stir thoroughly before use.
3. Avoid direct sunlight during delivery, storage and handling. Store in a cool, dry dark place under room temperature(5°C-35°C).
4. Keep container tightly closed and store upright. When spilled, absorb contents with sand.
5. During application(including touch-up application), color difference may occur depending on mixing ratio, painting tools and application method. It may occur in same color product and same LOT No.
6. Please check whether color difference occurred or not. If possible, apply the same LOT No. product in consistent application method.
7. Putty marks might appear when you directly apply over the lacquer coating. As time goes by, it can peel off.
8. Completely eliminate the moisture of spray equipment before use.  
Cleanse immediately after application not to have any leftover on spray equipment.
9. Suitable condition for application and hardening is 10°C or above.
10. Surface temperature must be at or above 3°C to avoid moisture condensation.
11. Do not mix with other paint products.
12. Proceed a test application before applying on a precedent or an old paint film (check adhesion, color spread and transparency).
13. Please refer to technical data sheet before system application(primer, midcoat and topcoat).
14. Please do not apply paint above 85% RH or below 5°C because it may influence physical properties.
15. Contents must not flow into drain, river and soil.
16. Hardener must be stored under room temperature, avoid direct sunlight and keep away from humidity.

17. To prevent environmental pollution, dispose contents after complete use and dispose the residue through waste disposal company authorized by the ministry of environment.
18. Beware of ingestion, inhalation and contact of animals and plants.
19. Use masking tape, covering tape, vinyl or newspapers to cover areas that should not be painted.

## ■ Health and Safety

1. Be well-informed of MSDS before use.
2. Keep out of the reach of infants and children. Do not apply a product to baby products and food containers.
3. Do not use a product for any other uses. (Sniffing is prohibited. Do not use as a fuel.)
4. If on skin or eye, wash thoroughly with running water and get a medical treatment.
5. Do not apply a product in an enclosed area.  
In order to prevent suffocation during application and drying, use power blower to keep the area fully ventilated. Workers must wear gas mask and safety gears all the time.
6. Contents include organic solvents and can cause health problems such as headache, dizziness and dermatitis.  
Do not ingest or inhale the product and avoid skin contact.  
Wear safety glasses, coveralls and latex gloves when mixing and applying.
7. Keep away from fire and heat during application or storage because it is flammable and has risk of fire.  
Beware of spark from impact, droppage and friction while handling.
8. Storing a product with combustible substances such as stained clothes or paper may cause fire by spontaneous ignition. Thus do not pile products with combustible substances.  
Keep it in a non-flammable container filled with water, then put a lid on and dispose it.
9. Please contact our customer service or refer to GHS-MSDS and technical data on the website for further details.

This data sheet is based on the test results and experiential bases of NOROO but might vary with the actual working environment and applying condition. This data is the intellectual property of NOROO Paint thus copying and distribution without permission are strictly prohibited. For more information, please contact the technical team or refer to our homepage. (<http://www.autorefinishes.co.kr>)